

Work Order ID 60766

July 22, 2010 10:45:06 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4062-1

Accept



Setup Start



Revision ID:

Item Name: Tank Support

Stop



Start Date: 23/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 26/07/2010 Req'd Qty: 2.00



Customer:

Reference: *10-07-22*



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4063	<i>A PAS</i>								

100 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D4062-1 BLANK

R 10-2-22



110 0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG D4062 & FOLIO FA949

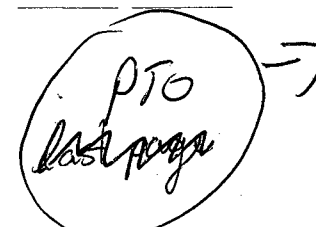
FOLIO REV: *AA*

DWG REV: *PAS*

DEBURR

8/10/07/25

1 1



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4062-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: ✓ Date: 10/7/26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>60766</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/07/25	110	One parts is off center By .250". R.C. operator error Bad origin	<u>[Signature]</u>	Scrap no replace	5# 10/07/25	S 10/07/26	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

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Required Date: 26/07/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SP 10/07/25

2

1



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

- inspect to passing only



QC

Memo

0.00

8,10/07/26 (SL)

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Work Order ID 60766

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Handwritten: A. conf. by Res. A.
10.07.30.

POSITIVE RECALL

EFFECTIVE 10.07.27 AUTH [Signature]

RELEASED _____ DATE _____

Picklist Print

Page 1

July 22, 2010 10:45:05 AM

Work Order ID: 60766



Parent Item: D4062-1



Parent Item Name: Tank Support


Start Date: 23/07/2010

Required Date: 26/07/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			100	sf	95.7473	3.6	7.2			



B10-7-22

Location

Loc Qty

Loc Code

MAT

95.7473

113903

86.9473

114624

8.8

113903

②

COVER PLATE 6061 .125

114325

114325

8 sq feet

tooling only.

DART AEROSPACE LTD	Work Order: 60766
Description: Tank support	Part Number: 04062
Inspection Dwg: 04062 Rev: PAS	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.00	±.030	43.00	✓		vern	8F 13 Tape
.75		.755	✓		vern	8F 12
.06		.060	✓		Dept Mics	8F 09
R.25		R.25	✓		vern	8F 13
.03		.041	✓			
2.71		2.71	✓			Measure with vern BUT NOT accurate.
.12		.120	✓			
2.69		2.69	✓			
.60		.580	✓			
14.71		14.714	✓		vern	A1000
15.00		15.00	✓		vern	A1000
3.00		3.00	✓		vern	Not accurate
4.59		4.600	✓			
5.00		5.00	✓			
15.00		15.00	✓		vern	A1000
14.45		14.450	✓		vern	A1000
.59		.59	✓			
.27		.27	✓			Not accurate
.30		.30	✓			
.23		.23	✓			
.50		.505	✓			
.25		.252	✓			
.94		.94	✓			

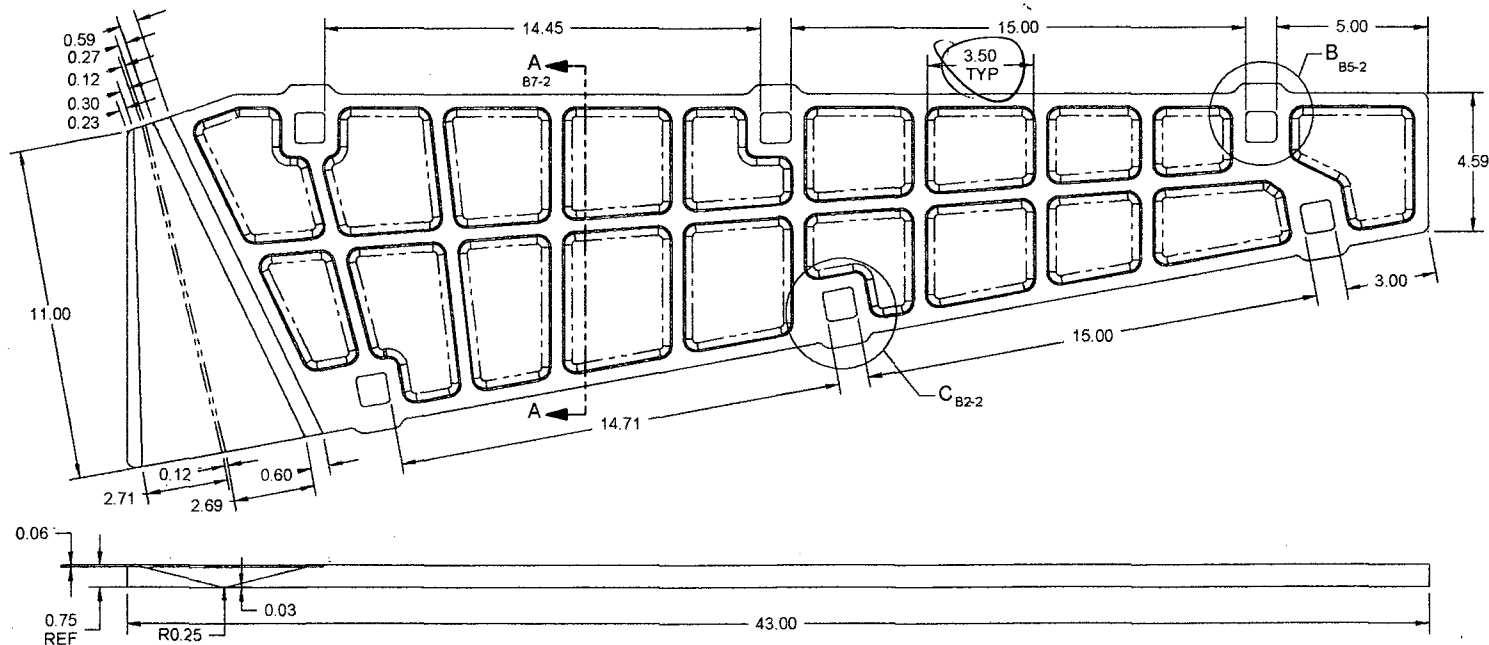
Measured by: 88
Date: 10/07/25

Audited by: 8
Date: 10/07/26

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D4062-1 TANK SUPPORT

NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 0.750 THICK
REF DART SPEC MUHMBW75
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.58 lbs
- 8) UN-DIMENSIONED FEATURES ARE DEFINED BY SOLIDWORKS MODEL "D4062-1A.SLDPRT"

PA5	NEW ISSUE		10.07.15
REV.		DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		D4062	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		TANK SUPPORT	NTS
DATE	10.07.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

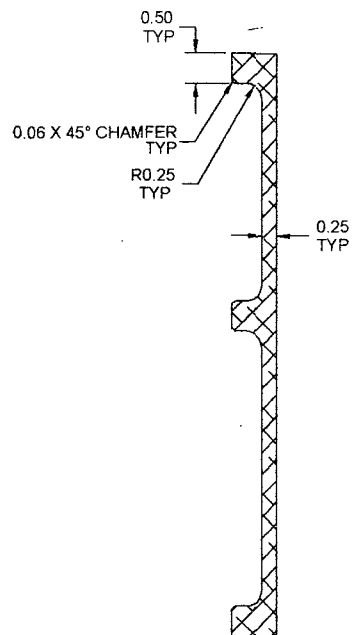
8 7 6 5 4 3 2 1

D

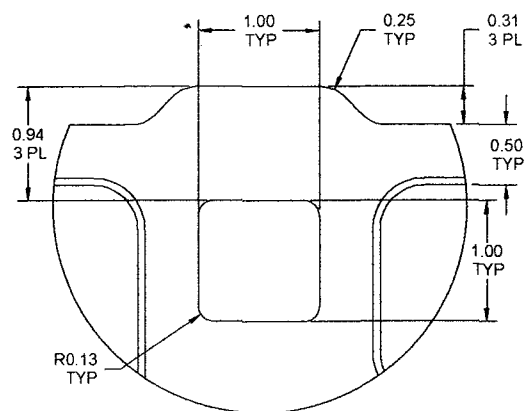
C

B

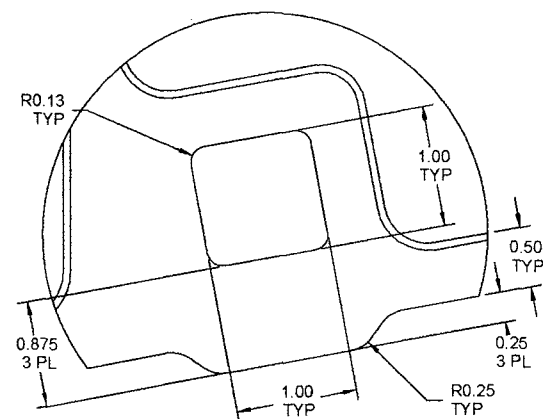
A



SECTION A-A C5-1
SCALE 2X



DETAIL B C2-1
SCALE 4X



DETAIL C B4-1
SCALE 4X

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		D4062	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		TANK SUPPORT	NTS
DATE	10.07.19	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

Receiving Report

Date: 10/2/5
 Supplier: SABIC

Batch No: M11 3903
 Part P/O: 11317

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QCS Inspection: 8 N/A ☒
 Work Order: 10242 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (If shipment OK) Level 12

Production/Admin: 10/2/8
 Date:
 Received/Costing:
 Initial:

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

 *** IF YOU ARE NOT CURRENTLY RECEIVING OUR INVOICES ***
 *** VIA EMAIL OR FAX, PLEASE SUPPLY US WITH AN EMAIL ***
 *** ADDRESS OR FAX NUMBER . FAX TO 905-789-3161 ***

SABIC
polymershapes

FEB 16 2010

سابك
sabic

INVOICE NO.	O089683/M
INVOICE DATE	05.02.10
TAKEN BY	melkertd
G.S.T. REG. NO.	856372750RT0001
CARRIER	

PST 85637 2750 TR000

INVOICE

SOLD TO: DART AEROSPACE LTD

SHIP TO: DART AEROSPACE LTD

1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
Canada

1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7
Canada

A/C 22.32

CUSTOMER DARAER	SHIP VIA EPIC	TAX LIC 1 CHARGE GST	TAX LIC 2 6112-5207	INVOICE TERMS NET 30 DAYS	SALES ORDER O89930	PAGE 1	WHS. 99		
CUSTOMER P.O. PO11317	SHIP DATE 05.02.10	FREIGHT TERMS PREPAID + CHARGE	SALES REP. WADE DIXON	S.D.N. 01	BILL OF LADING	Sch. Date 29.01.10	Sales Office 99		
LN	PRODUCT	ORDER	B/O	SHIP	SKU	DESCRIPTION	PRICE	PER	EXTENSION
001	93314755	8	0	8	SHT	TIVAR 1000 PLATE - BLACK 1.000 X 48 X 120 - +.030/ FREIGHT	1 810.81	SHT	6486.48 125.00
003	0000005	1	0	1	EA	THANK YOU FOR SELECTING SABIC POLYMERSHAPES GST PAYABLE @ 5% PLEASE PAY THIS AMOUNT	1 .00	EA	0.00 330.57 ----- 6942.05 =====
***** *** IF YOU ARE NOT CURRENTLY RECEIVING OUR INVOICES *** *** VIA EMAIL OR FAX, PLEASE SUPPLY US WITH AN EMAIL *** *** ADDRESS OR FAX NUMBER . FAX TO 905-789-3161 *** ***** *									

PLEASE Remit To: SABIC Polymershapes 9150 Airport Road Brampton ON L6S 6G1

Phn : (613)745-7043 Fax : (613)745-4291

NO GOODS TO BE RETURNED WITHOUT APPROVAL FROM US. ALL DISCREPANCIES MUST BE REPORTED WITHIN 3 DAYS.

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: FEBRUARY 4, 2010

YOUR PURCHASE ORDER: PO11317

OUR SHIPPER NO: O89930

SABIC POLYMERSHAPES LINE ITEM # 001

QUANTITY: 8 SHEETS

S
10/02/08

DESCRIPTION: TIVAR 1000 COLOURED PLATE BLACK 1"
PLANED-FLYCUTTER, +.020-0

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:

QUADRANT PRODUCT SUPPLIED UNDER THIS ORDER MEETS: ASTM D 4020-05 WITH A
MOLECULAR WEIGHT OF 3.0 TO 6.2 MILLION G/MOL

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIRMENTS OF
THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT
SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST
REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE



DARLEEN MELKERT
INSIDE SALES REPRESENTATIVE